

# Work Order ID 74887

October 13, 2011 11:19:44 AM

**\*74887\***

Page 1

Item ID: D3806-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bar  
 Start Date: 10/13/11 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 11/15/11 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100 0.00  
**\*100\***  
 Cold Saw  
 Hyd Mech  
 Memo  
 Cut blanks at 43.600"  
 FK- 11/11/08 20

110 0.00  
**\*110\***  
 HAAS I  
 HAAS CNC vertical machine #1  
 Memo  
 1-Mill as per folio FB070 & dwg  
 FOLIO REV: B  
 DWG REV: B  
 2-Deburr as required  
 FK- 11/11/08 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00				<u>20</u>			
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				<u>20</u>			
133 <b>*133*</b> Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: _____  Memo 1- On D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805 2059 B Hardcoat Welding Rod BATCH#: _____	0.00 0.00							

*will be done on assembly w/o U*

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 <b>*136*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00							
137 <b>*137*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00							
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>W/A</i>  Memo	0.00							

*assembly w/o* *W*  
*A*  
*A* *11/11-29* *(20)*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 74887**

October 13, 2011 11:19:44 AM

**\*74887\***

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Item ID: D3806-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bar

Start Date: 10/13/11 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 11/15/11 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00


**\*150\***

QC

Memo

0.00

Quality Control

11/11/30 ME  
11-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

October 13, 2011 11:19:49 AM

Page 1

Work Order ID: 74887

**\*74887\***

Parent Item: D3806-1

**\*D3806-1\***

Parent Item Name: Bar

Start Date: 10/13/11

Required Date: 11/15/11

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP Rev:A 08-07-21 new issue DD verified by:ec

IPP Rev:B 08-09-23 redesign DD verified by:EC

IPP Rev:C 08-09-30 redesign DD verified by:EC

D 11.06.03 re-design EC verified by:DD

rev.b as per dwg DD verified by:EC

IPP rev  
IPP Rev:E 11.10.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.250x0.500

Purchased

No

100

f

1,482.142

3.66

77.05263

**\*M304B0 250x0 500\***

\*\*

*FK 11/11/08*

304 BAR .250 x .500

## Location

## Loc Qty

## Loc Code

MAT006

1421.128

117842

8.3

119050

21.67

119159

1391.158

MAT050

61.0147

117176

61.0147

77.053

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	<del>217812</del>
Description: Bar		Part Number:	D3806-1
Inspection Dwg: D3806      Rev: <del>A</del> B			Page 1 of 1



## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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[illegible]

2/A  
11-11-08

Measured by: <i>F.R.</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: <i>11/11/09.</i>	Date: <i>4/11/9</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

D3806-1 BAR

D3806-5 BAR

D3806-3 BAR

D3806-7 BAR

RELEASED  
2011-10-03  
*MB*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. *74887* *M.C.J.*  
*11/10/12*

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PAR11-106	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ap</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>ap</i>	DRAWING NO.	REV. B
CHECKED	<i>ap</i>	D3806	SHEET 1 OF 3
MFG. APPR.	<i>ap</i>	TITLE	SCALE
APPROVED	<i>ap</i>	BAR	NTS
DE APPR.	<i>ap</i>	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	11.09.29		

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

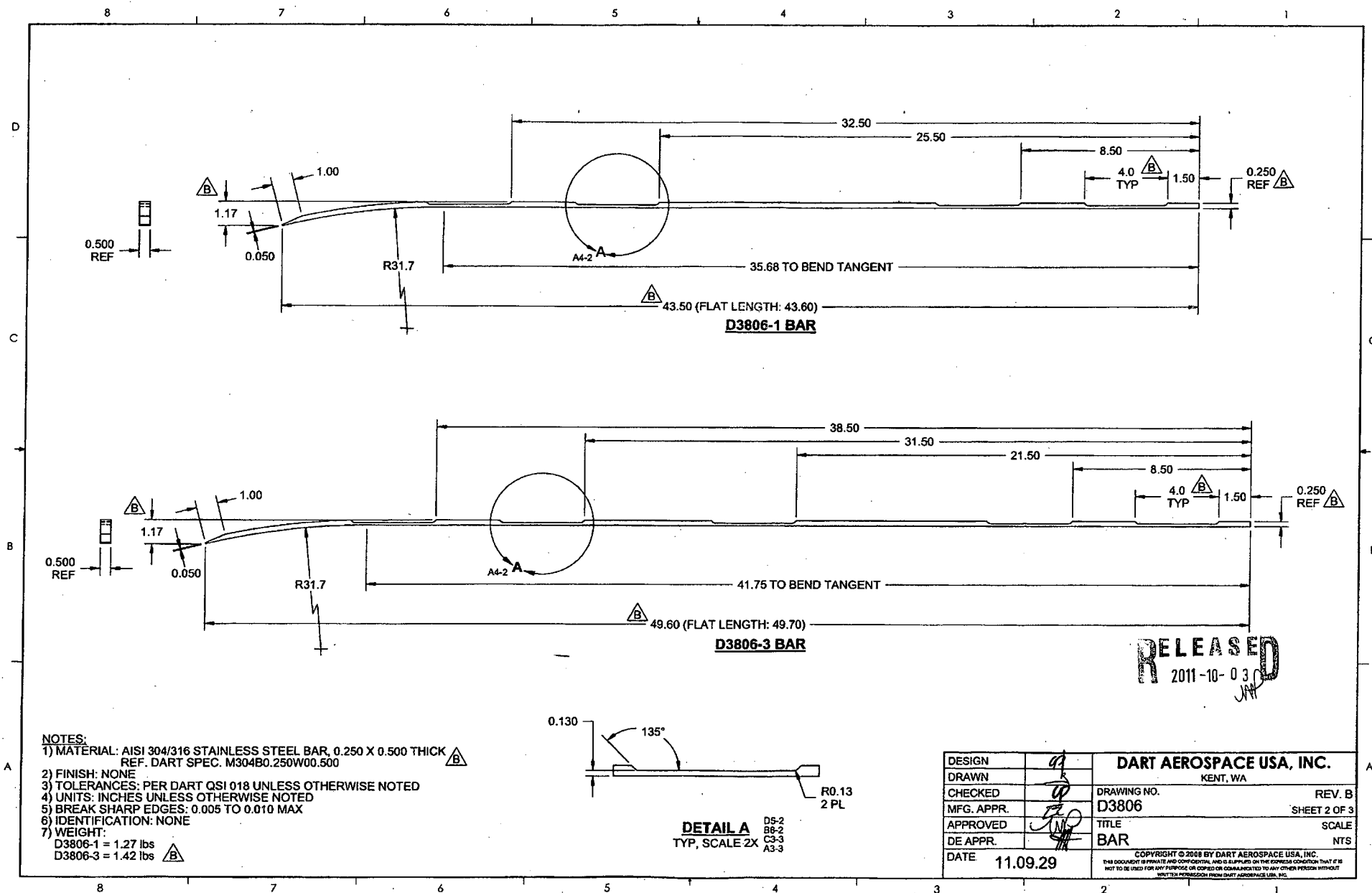
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

74887

~~74887~~

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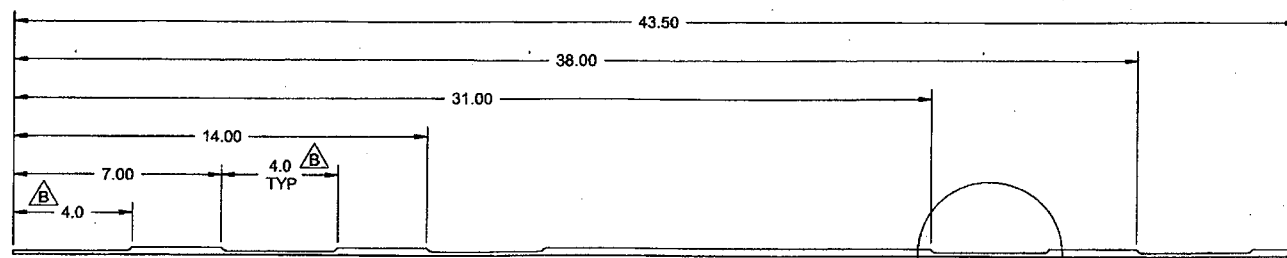
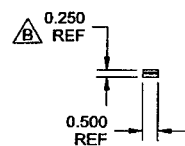
**NOTE:** Date & initial all entries



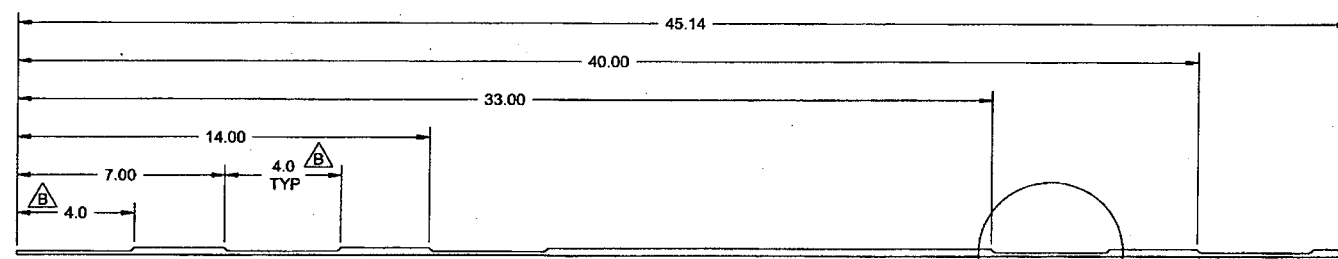
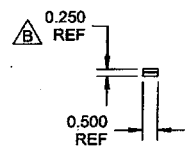
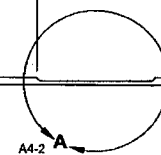
74887

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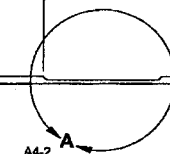
8 7 6 5 4 3 2 1



**D3806-5 BAR**



**D3806-7 BAR**



**RELEASED**  
2011-10-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK  
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:  
D3806-5 = 1.22 lbs  
D3806-7 = 1.28 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	11.09.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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